



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2563

Job Sheet 195380



DAS
24
9-89

2

Part No: D2563

Job Qty: 2 pcs

Part Name: Step Weldment Assembly



Part Weight: 0 lbs

Job Created: 5/21/19

Due Date: 6/10/19

Type: Stock

Note: DWG REV C IPP Rev:G 02.07.31 Re-format Location RF

Ship Via:

Status: New

Priority: Medium

Job Tracking No:

Created By: Jennifer Renwick

Description:

NOT ENOUGH PARTS
TO MAKE 4

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Run Hrs Hrs	Workcenter/Supplier		Sign-off
						Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	2 pcs	6/10/19	0.00 2.94		Large Fab - 1		
						Large Fab - 10		
						Large Fab - 2		
						Large Fab - 3		
						Large Fab - 4		
						Large Fab - 5		
						Large Fab - 6		
						Large Fab - 7		
						Large Fab - 8		
110	QC 9	2 pcs	6/10/19	0.00 0.00		Large Fab - 9		
						QC 9 - 10		
						QC 9 - 18		
						QC 9 - 24		
						QC 9 - 43		
						QC 9 - 50		
120	QC 5	2 pcs	6/10/19	0.00 0.00		QC 9 - 9		
						QC 5 - 10		
						QC 5 - 12		
						QC 5 - 17		
						QC 5 - 18		
						QC 5 - 19		
						QC 5 - 22		
						QC 5 - 24		
						QC 5 - 3		
						QC 5 - 43		
						QC 5 - 49		
						QC 5 - 51		
						QC 5 - 58		
						QC 5 - 68		
						QC 5 - 9		
						QC 5 - 50		
						QC 5 - 30		
130	Handfinish - 1-1 Chemical- B4B	2 pcs	6/10/19	0.00 0.54		QC 5 - 40		
						Handfinish - 1 - 1 - B4B		
						Handfinish - 1 - 2 - B4B		
						Handfinish - 1 - 3 - B4B		
						Handfinish - 1 - 4 - B4B		
						Handfinish - 1 - 5 - B4B		
						Handfinish - 1 - 6 - B4B		
						Handfinish - 1 - 7 - B4B		
						Handfinish - 1 - 8 - B4B		
						Handfinish - 1 - 9 - B4B		

Plex 5/21/19 10:51 AM Dart.Renwick.Jennife

					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
					QC 7 - 10	
140 QC 7	2 pcs	6/10/19	0.00 0.00		QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
150 Large Fab - Welded Assy-2-B4B	2 pcs	6/10/19	0.00 2.94		Large Fab - 1 - B4B	
					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
160 QC 10	2 pcs	6/10/19	0.00 0.00		QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	
					QC 10 - 58	
170 QC 5	2	6/10/19	0.00 0.00		QC 10 - 9	
					QC 5 - 10	

DAS
43
9-89DAS
43
9-89DAS
24
9-89

MAY 29 2019

pcs						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
175	Handfinish - 2-1 Pressure- B4B	2	6/10/19	0.00	0.54	Handfinish - 2 - 1 - B4B	
	pcs					Handfinish - 2 - 2 - B4B	
						Handfinish - 2 - 3 - B4B	
						Handfinish - 2 - 4 - B4B	
180	Powdercoat - 1 White (A)- B4B	2	6/10/19	0.00	0.33	Powdercoat - 1 - B4B	
	pcs					Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
190	Handfinish - 3-1- WingWalk- B4B	2	6/10/19	0.00	0.54	Handfinish - 3 - 1 - B4B	
	pcs					Handfinish - 3 - 2 - B4B	
						Handfinish - 3 - 3 - B4B	
						Handfinish - 3 - 4 - B4B	
						Handfinish - 3 - 5 - B4B	
200	QC 3	2	6/10/19	0.00	0.00	QC 3 - 10	
	pcs					QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
210	Packaging 3-1 - Stock - B4B	2	6/10/19	0.00	0.00	Packaging 3 - 1 - B4B	
	pcs					Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	

				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220 QC 21 - SA	2	6/10/19	0.00 0.00	QC 21 - SA - 21	
	pcs			QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Cut D2244 to 89.70" at 34 deg as per dwg D2563 2-Debur ends
 Descriptions: 3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343 4- Grind
 110 - (QC9- Inspect visual per QSI004- Fusion Welds)
 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Chemical Conversion Coat per QSI005 4.1)
 140 - (QC7-Inspect Chemical Conversion Coat)
 150 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Inspect for foreign object per QSI 024 2-Weld Remaining End cap
 as per Dwg D2563 using DT 8343 3-Grind
 160 - (QC10- Inspect visual per QSI004- ground welds)
 170 - (QC5- Inspect part completeness to step on W/O)
 175 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Touch up Alodine as per QSI005
 180 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as
 per QSI 005 4.3 START TIME: _____
 190 - (Wing Walk as per dwg QSI005 4.4 Batch: 5185147)
 200 - (QC3- Inspect Part Finish)
 210 - (Identify as per dwg & Stock Location: _____)
 220 - (QC21- Final Inspection - Work Order Release)

010026

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	2 pcs (1 ea)	100-Large Fab - Welded Assy-1	5081118
D2561	Lug	4 pcs (2 ea)	100-Large Fab - Welded Assy-1	5160076
D2564	Mounting Angle	4 pcs (2 ea)	100-Large Fab - Welded Assy-1	5165433
D2673-34	End Plate	2 pcs (1 ea)	100-Large Fab - Welded Assy-1	5161432
D2673-34	End Plate	2 pcs (1 ea)	150-Large Fab - Welded Assy-2- B4B	5161432

DAS 43 9-89

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D2244-116	2	23	0
	D2561	4	10	0
	D2564	4	33	0
	D2673-34	2	15	0
	D2673-34	2	15	0
150-Large Fab - Welded Assy-2- B4B				

Part Specifications	
Specifications could not be found.	

Plex 5/21/19 10:51 AM Dart.Renwick.Jennifer



Container No: S184853



Part: D2563

Job No: 195380

Serial No/Batch: S184853

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/29/19